

Work Order ID 53163

October 23, 2009 1:29:53 PM



Page 1

Item ID: D3144-105

Accept



Setup Start



Revision ID: C

Item Name: Doubler

Stop



Start Date: 10/30/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3144

Rev C

100

0.00



PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3144-105

Dwg Rev:

Prog Rev:

2-Deburr if necessary

2004
030

B 9-11-6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-11-6

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Accept



Setup Start



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Stop



Item Name: Doubler

Start Date: 10/30/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

[Handwritten signature]

09

11

10

4

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Debur

B 9-11-10

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

[Handwritten signature] 09/11/11

YF

Ø

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Page 3

Item ID: D3144-105

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 10/30/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



1109091

Powdercoat

Memo

0.00

Powder Coating

START TIME: 4:00am
OVEN TEMPERATURE: 320°
FINISH TIME: 11:30am

9/11/11

(XL) 0

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-11-11

(4)

170

Identify as per dwg & Stock Location: 1A

0.00



Packaging

Memo

0.00

Packaging

9/11/11 (4) SP

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Page 4

Item ID: D3144-105

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 10/30/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/12
MF
09-11-11

Picklist Print

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Page 1

Work Order ID: 53163



Parent Item: D3144-105RevC



Parent Item Name: Doubler

Start Date: 10/30/09

Required Date: 10/30/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	59.3122	0.8632			



2024-T3 .032 sheet



B 9-11-6

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

59.31223158

102942

1.5

105555

4.0684

106272

5.3

108595

1.2

109240

7.02

110778

18.8996316

111699

18.3242

18147

3

110778

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RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ONLY

NO.

DART

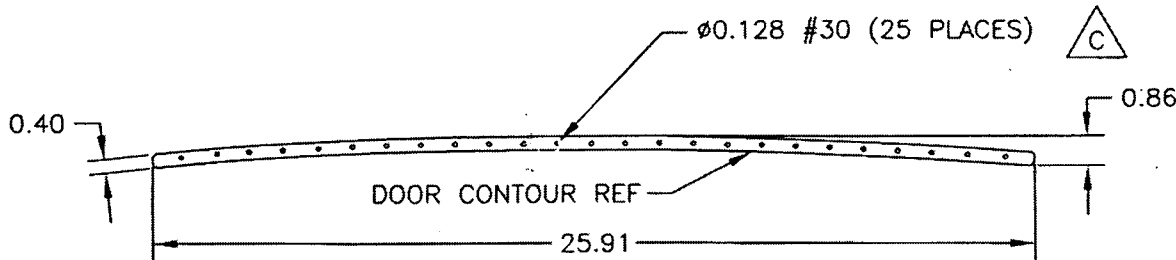
05.11.14
05.10.19

53163

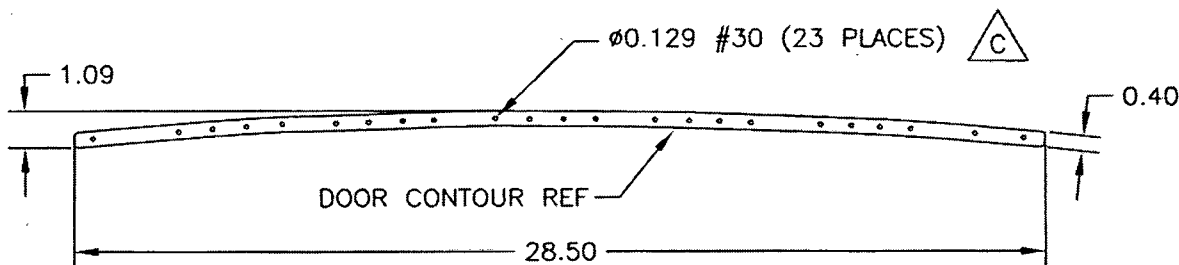
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RELEASED

05.11.14



D3144-1 DOUBLER (FOR D412-694-03)
REPLACES PREMIER P/N B30-23000-191



D3144-3 DOUBLER (FOR D412-694-01)
REPLACES PREMIER P/N B30-23000-193

D3144-1/-3 NOTES:

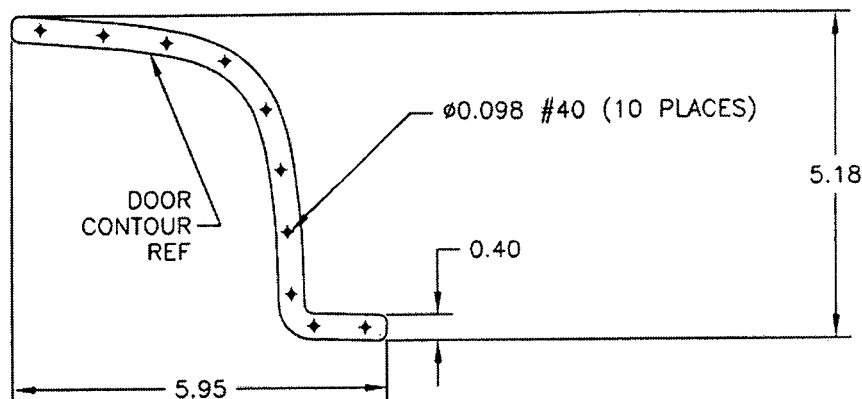
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C1.DWG"

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
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DATE	05.10.19	TITLE	DOUBLER	REV. C
				SHEET 1 OF 9
				SCALE
				1:5
A		02.04.22	NEW ISSUE	
B		04.09.17	ADDED D3144-105/-107/-109/-111/-115/-121/-123; MODIFY D3144-1	
C		05.10.19	ADD D3144-15; 0.129 WAS 0.098	



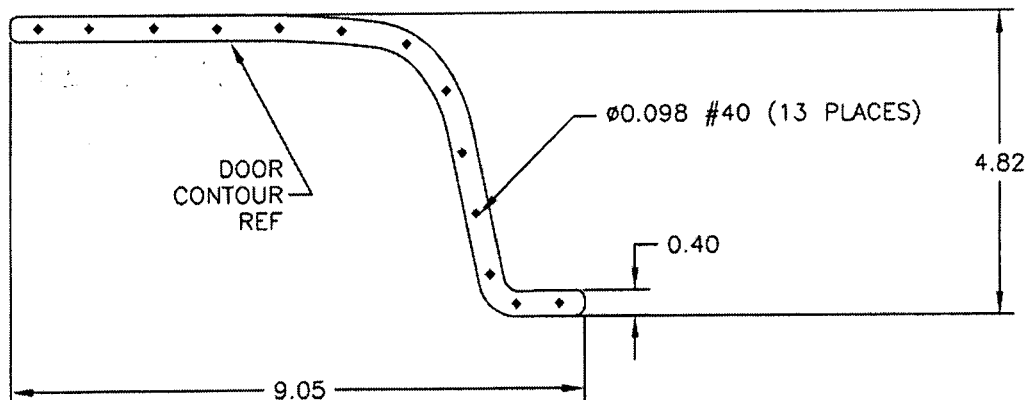
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



D3144-5 DOUBLER

REPLACES PREMIER P/N B30-23000-195



D3144-7 DOUBLER

REPLACES PREMIER P/N B30-23000-197

D3144-5/-7 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C2.DWG"

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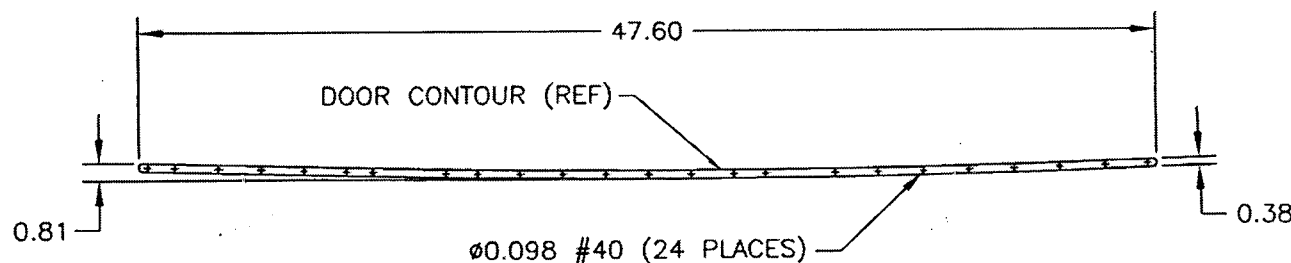
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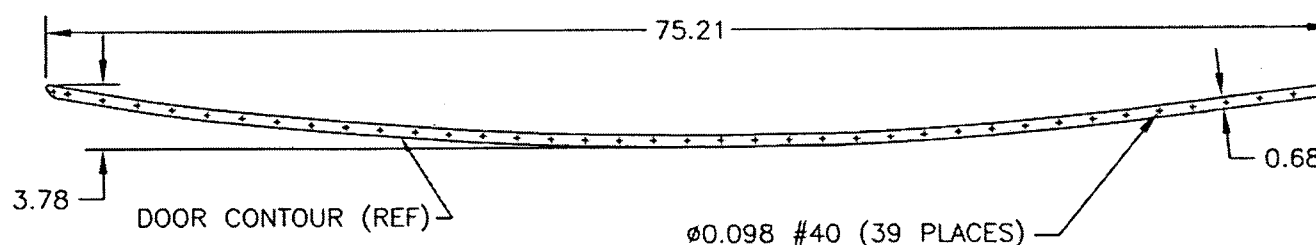


D3144-15 DOUBLER
SCALE 1:8



D3144-15 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"



D3144-13 DOUBLER
SCALE 1:10

REPLACES PREMIER P/N B30-23000-211

D3144-13 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"

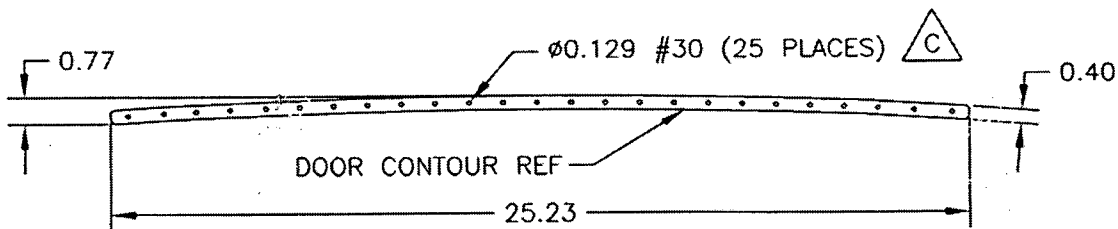
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		D3144	SHEET 4 OF 9	
DATE		TITLE	SCALE	
05.10.19		DOUBLER	NTS	

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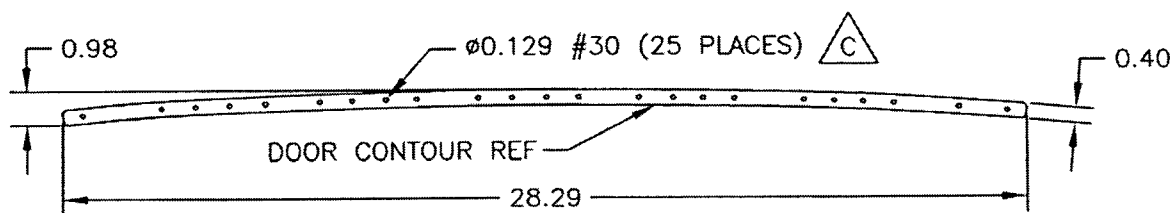
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D3144-119 DOUBLER (FOR D412-694-04)



D3144-123 DOUBLER (D412-694-02)

D3144-119/-123 NOTES:

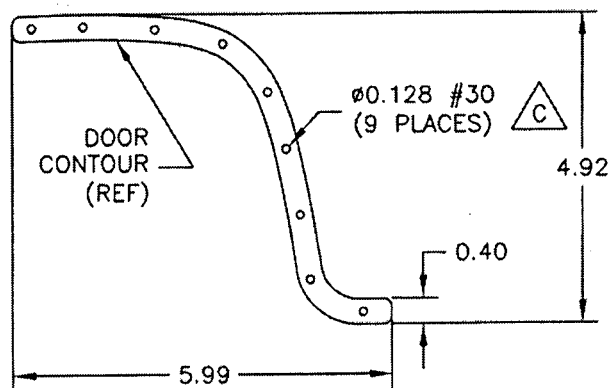
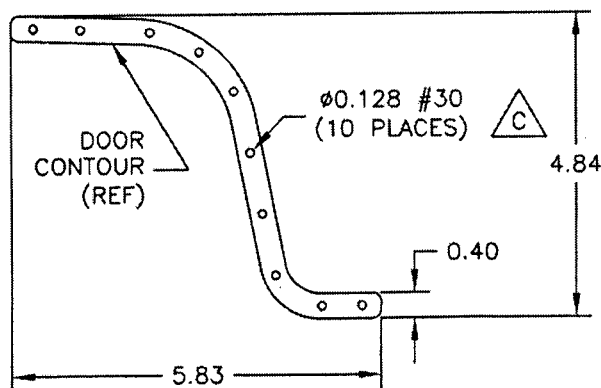
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C5.DWG"

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		DRAWING NO.	D3144	SHEET 5 OF 9
		SCALE	NTS	

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DATE 05.10.19		TITLE DOUBLER	SCALE NTS

**D3144-105 DOUBLER (FOR D412-694-03)****D3144-117 DOUBLER (FOR D412-694-04)****RELEASED**05.11.14 *[Signature]***D3144-105/-117 NOTES:**

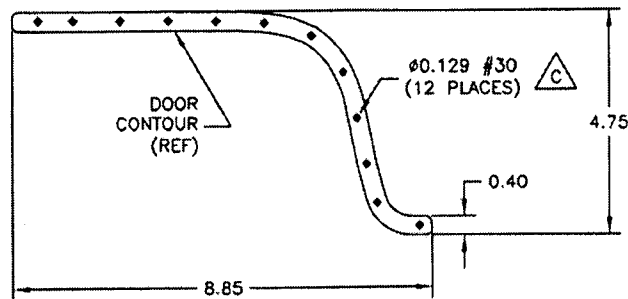
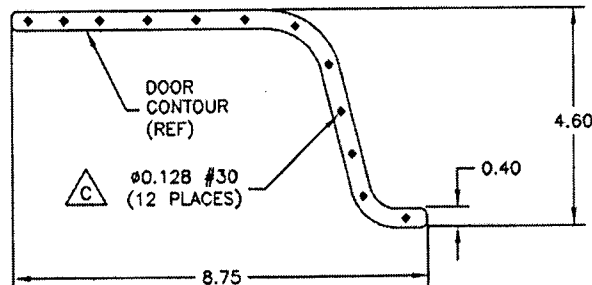
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C6.DWG"

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DATE 05.10.19		TITLE DOUBLER	SCALE NTS

**D3144-107 DOUBLER (FOR D412-694-03)****D3144-121 DOUBLER (FOR D412-694-04)****RELEASED**

05.11.14

D3144-107/-121 NOTES:

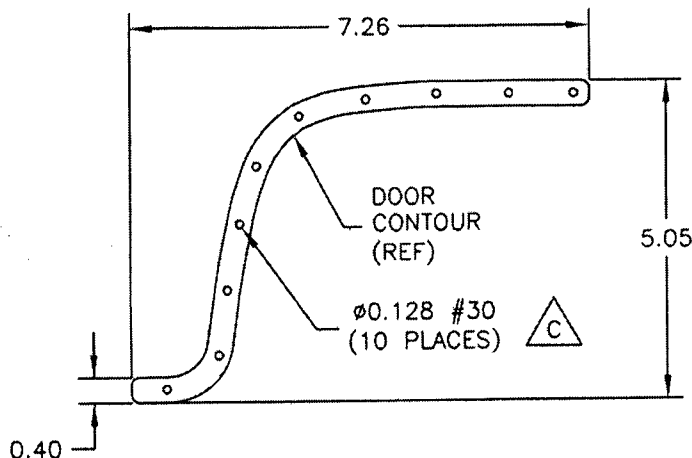
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C7.DWG"

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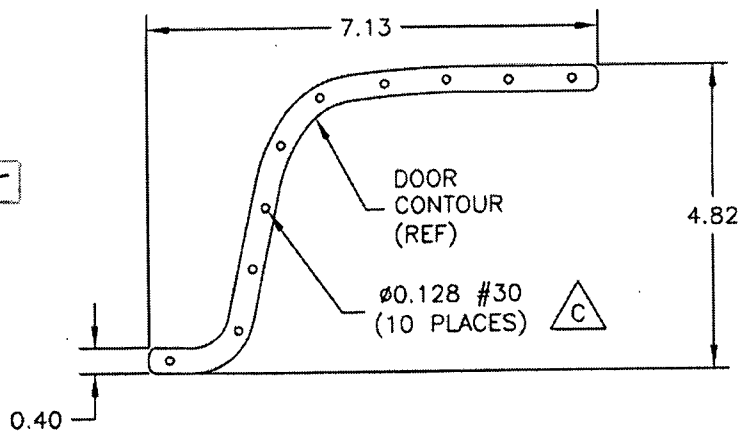
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



D3144-109 DOUBLER (FOR D412-694-01)



D3144-115 DOUBLER (FOR D412-694-02)

D3144-109/-115 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C8.DWG"

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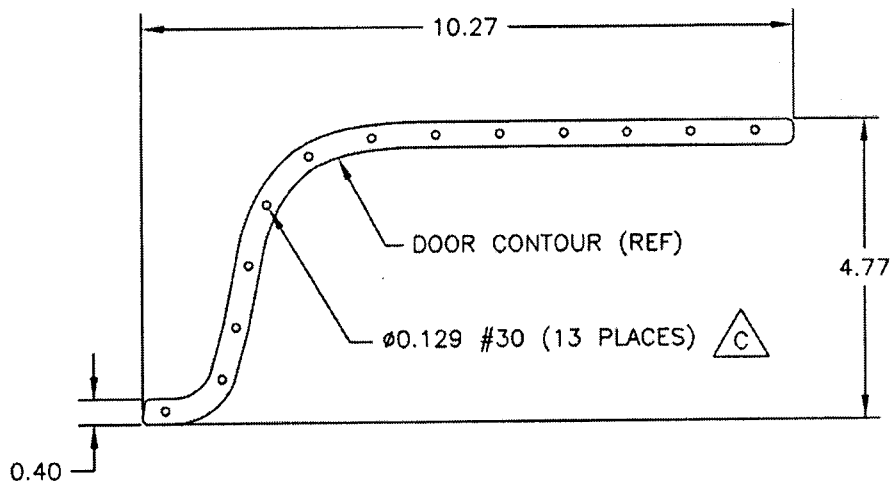
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS

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05-11-14



D3144-111 DOUBLER (FOR D412-694-01/-02)

D3144-111 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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- 6) MACHINE PER DRAWING "D3144-C9.DWG"

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